

Date: Thursday, 14/09/2006 11:43:46 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D2492	
Job Number	: 28593		Part Number	: D2492	
Estimate Number	: 10804		Drawing Number	: REWORK PER REV.F	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 14/09/2006	S.O. No. : N/A	Drawing Revision	: N/A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 21/09/2006 Qty: 10 Um: Each	
Previous Run	: 00015				
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
Comment: SMALL & MEDIUM FAB RESOURCE 1 REMOVE FROM STOCK D2492 B <u>25271</u> <i>JK</i> <u>06/09/14</u>				
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
Comment: SMALL & MEDIUM FAB RESOURCE 1 REDRILL HOLES TO 1.25 PER DRWG D2492 REV.F <i>JK</i> <u>06/09/14</u> <i>10</i>				
3.0	QC5	INSPECT WORK TO CURRENT STEP		
Comment: INSPECT WORK TO CURRENT STEP <i>JK</i> <u>06.09.14</u> <i>10</i>				
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
Comment: HAND FINISHING RESOURCE #1 TOUCH UP ALODINE / PAINT (IMRON) <i>JK</i> <u>06/10/12</u> (4) <i>JK</i> <u>06/09/22</u> (6)				
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>JK</i> <u>06/10/12</u> <i>10</i>				
6.0	PACKAGING 1	PACKAGING RESOURCE #1		
Comment: PACKAGING RESOURCE #1 BAG & TAG USING NEW B/N <i>JK</i> <u>06/10/13</u> <i>x4</i>				

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Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE



(18)

Comment: FINAL INSPECTION/W/O RELEASE

206/10/16

Job Completion

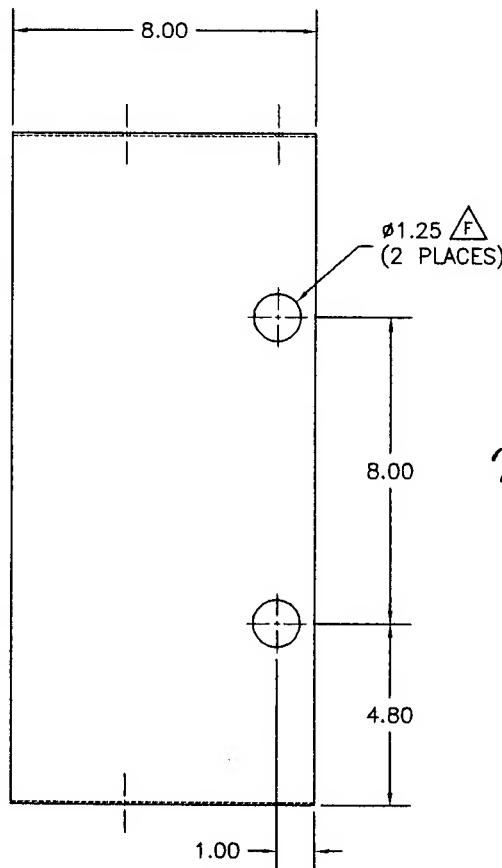
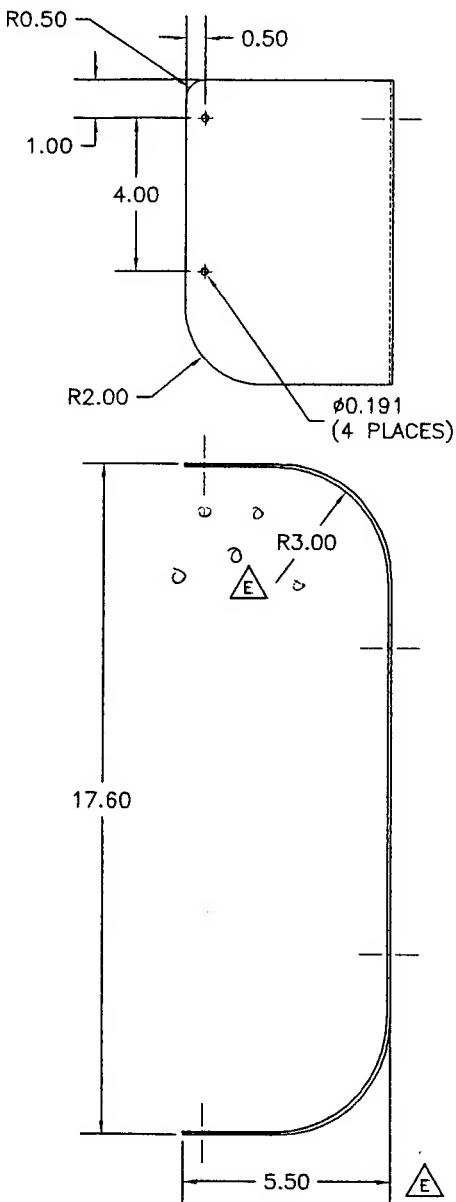


W 26.10.13

PRELIMINARY ISSUE

06.09.14 15

DESIGN KE	DRAWN BY <i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14		TITLE PATIENT STOP	SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	



D2492 PATIENT STOP

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

L Lacelle

From: Marc Bellavance [mbellavance@dartaero.com]
Sent: September 14, 2006 11:05 AM
To: Trepanier, Dale; Stow, Dan; Charbonneau, Eric; Murdoch, Jason; Menard, Jean-Luc; Johnston, Kim; Lacelle, Linda; Shahbazian, Serge
Cc: Beckett, Bill; Shepherd, David
Subject: D2492 Rev. E - UNDER REVIEW

Drawing D2492 Rev. E for the Patient Stop is now under review.

Kim,

Please scan the drawing and move the PDF drawing file in the Under Review directory.

Linda,

All in-stock/in-production parts should be reworked as follows: the Ø1.020" are too small and should be enlarged to Ø1.250".

Eric/Jean-Luc,

The program used on the waterjet will have to be updated.

David,

D2492 Rev. F will follow for your review.

Thanks!

Marc Bellavance
Mechanical Designer

DART aerospace Ltd.

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No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.1.405 / Virus Database: 268.12.3/447 - Release Date: 9/13/2006

DART AEROSPACE LTD

Work Order: 28593

Description: Patient STOP

Part Number: D2492

Inspection Dwg: D2492 Rev: F

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by

Audited by:

Prototype Approval:

Date _____

06/09/14

Date: 06.09.14

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	